

Date: Wednesday, 3/14/2007 3:29:16 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                     |                  |                |
|-----------------------|-------------------------------------|------------------|----------------|
| Customer              | CU-DAR001 Dart Helicopters Services | Drawing Name     | BRACKET        |
| Job Number            | 31216                               | Part Number      | D35461         |
| Estimate Number       | 12538                               | Drawing Number   | D3546 REV A    |
| P.O. Number           | N/A                                 | Project Number   | N/A            |
| This Issue            | 3/14/2007                           | S.O. No.         | N/A            |
| Prsht Rev.            | NC                                  | Drawing Revision | A              |
| First Issue           | 3/14/2007                           | Type             | SMALL /MED FAB |
| Previous Run          | 29766                               | Material         | N/A            |
| Written By            |                                     | Due Date         | 3/23/2007      |
| Checked & Approved By | <u>HD 07.03.15</u>                  | Qty:             | 40             |
| Comment               | Est Rev:A New Issue 06-09-27 JLM    | Um:              | Each           |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation:  | Description :                          |
|---------|--|--|
| 1.0     | M304S18GA  | 304/316 .050 Sheet                     |
|         |  |  |
|         | Comment: Qty.: 0.2205 sf(s)/Unit Total : 8.8200 sf(s)<br>304 SS SHEET 18GA<br>Batch: M100997 |  |
| 2.0     | WATER JET  | FLOW WATER JET                         |
|         |  |  |
|         | Comment: FLOW WATER JET<br>1-Cut as per Dwg D3546<br>Dwg Rev: A<br>Prog Rev: A               |  |
|         | 2-Deburr if necessary  |  |
| 3.0     | QC2  | INSPECT PARTS AS THEY COME OFF MACHINE |
|         |  |  |
|         | Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |  |
| 4.0     | QC8  | SECOND CHECK                           |
|         |  |  |
|         | Comment: SECOND CHECK  |  |
| 5.0     | BRAKE NC   | NC BRAKE                               |
|         |  |  |
|         | Comment: NC BRAKE<br>Form as per Dwg D3546   |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/08  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:29:16 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31216

Part Number: D35461

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/03/26 (40)

7.0 POWDER COATING POWDER COATING



N1103706

(40x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L

07/03/26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 07/03/27

(40)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

107/03/27 (40)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/03/28

(40)

Job Completion



107/03/28

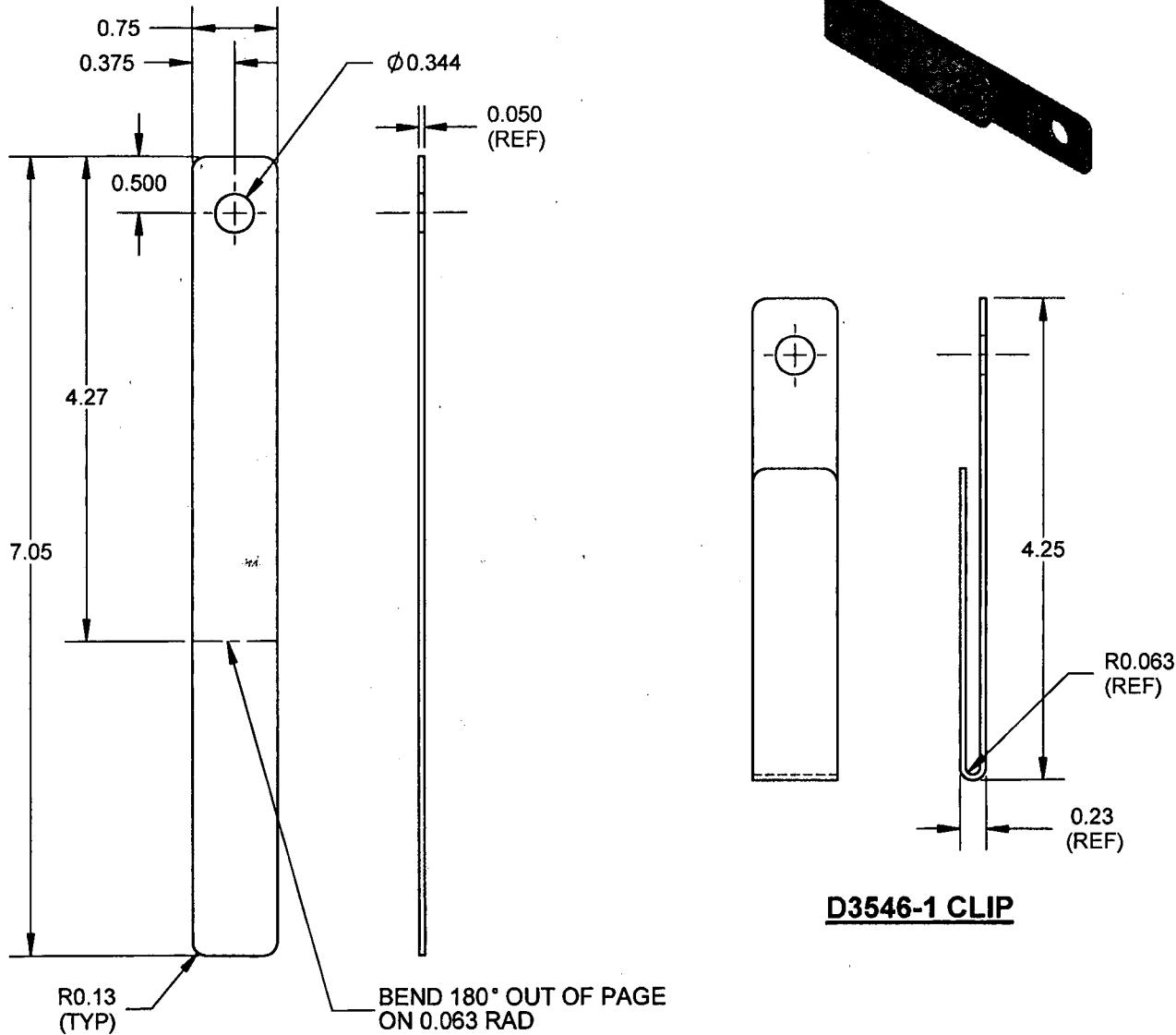
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                      |                       |   |
|----------------------|-----------------------|---|
| DESIGN<br><i>LE</i>  | DRAWN BY<br><i>LE</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>RP</i> | APPROVED<br><i>JH</i> | DRAWING NO.<br>D3546                              |
| DATE<br>06.09.15     |                       | TITLE<br>CLIP                                     |
| REV<br>A             | DATE<br>06.09.15      | SCALE<br>1:1                                      |
| REV<br>A             | DATE<br>06.09.15      | DESCRIPTION<br>NEW ISSUE                          |



D3546-1 CLIP

D3546-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31216

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

|                              |  |              |         |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD           |  | Work Order:  | 31216   |
| Description: BRACKET         |  | Part Number: | D3546-1 |
| Inspection Dwg: D3546 Rev: A |  | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

| Inspection Sheet Drawing Dimension | Tolerance        | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|------------------|------------------|--------|--------|----------------------|----------|
| A 7.05                             | +/- 0.030        | 7.05             | /      |        | Vern                 |          |
| B 0.500                            | +/- 0.010        | 0.497            | /      |        | Vern                 |          |
| C 0.750                            | +/- 0.010        | 0.754            | /      |        | Vern                 |          |
| D 0.375                            | +/- 0.010        | 0.374            | /      |        | Vern                 |          |
| E 0.050                            | +/- 0.010        | 0.049            | /      |        | Vern                 |          |
| F Ø 0.344                          | +0.006<br>-0.001 | Ø 0.346          | /      |        | Vern                 |          |
| G                                  |                  |                  |        |        |                      |          |
| H                                  |                  |                  |        |        |                      |          |
| I                                  |                  |                  |        |        |                      |          |
| J                                  |                  |                  |        |        |                      |          |
| K                                  |                  |                  |        |        |                      |          |
| L                                  |                  |                  |        |        |                      |          |
| M                                  |                  |                  |        |        |                      |          |
| N                                  |                  |                  |        |        |                      |          |
| O                                  |                  |                  |        |        |                      |          |
| P                                  |                  |                  |        |        |                      |          |
| Q                                  |                  |                  |        |        |                      |          |
| R                                  |                  |                  |        |        |                      |          |
| S                                  |                  |                  |        |        |                      |          |
| T                                  |                  |                  |        |        |                      |          |
| U                                  |                  |                  |        |        |                      |          |
| V                                  |                  |                  |        |        |                      |          |
| W                                  |                  |                  |        |        |                      |          |
| X                                  |                  |                  |        |        |                      |          |
| Y                                  |                  |                  |        |        |                      |          |

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | SAD      | Audited by: |          | Prototype Approval: | N/A |
| Date:        | 07/03/19 | Date:       | 07/03/19 | Date:               | N/A |

|     |      |           |            |          |
|-----|------|-----------|------------|----------|
| Rev | Date | Change    | Revised by | Approved |
|     |      | New Issue | KJ/RF      |          |

